

Date: Friday, 7/4/2008 8:46:59 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET
Job Number	40252		Part Number	D31991
Estimate Number	10283		Drawing Number	D3199 REV B
P.O. Number	:		Project Number	N/A
This Issue	7/4/2008	S.O. No. :	Drawing Revision	B
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : SMALL /MED FAB	Due Date	7/21/2008 Qty: 40 Um: Each
Previous Run	39843			
Written By	:			
Checked & Approved By	:			
Comment	Est Rev:C	Removed Scribing 05-11-05	JLM	
	Est Rev:D	As per Rev B 06-11-24	JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		5,
		Comment: Qty.: 0.1040 sf(s)/Unit Total : 4.1580 sf(s) 304/316 .040" SHEET Batch: 108156
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: B Prog Rev: B
		Deburr if required
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-7-17
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 40252		Part Number: D31991
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>(Handwritten: 46x)</i>
Comment: INSPECT WORK TO CURRENT STEP		<i>S 08/08/14</i>
7.0	POWDER COATING	POWDER COATING <i>M 10 6442</i> <i>(Handwritten: 46x)</i>
Comment: POWDER COATING		POWDER COATING
Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
START TIME: <i>1-45</i>		
OVEN TEMPERATURE: <i>320° F</i>		
FINISH TIME: <i>2-15</i>		<i>M-A 08/10/15</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>(Handwritten: 46)</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>FZ 08/10/15</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>(Handwritten: 46)</i>
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: <i>ST233A</i>		<i>18 08/10/15 46</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE <i>08/10/17 HJ</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		<i>MF 08-10-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40252
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

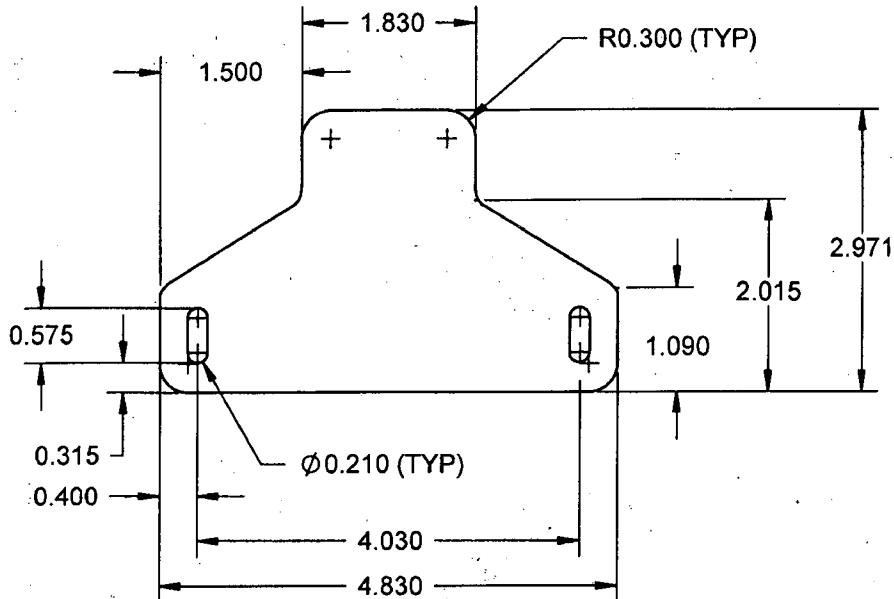
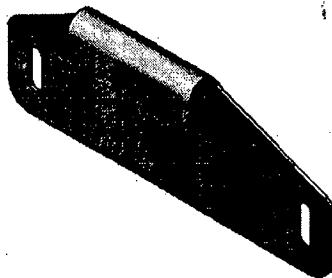
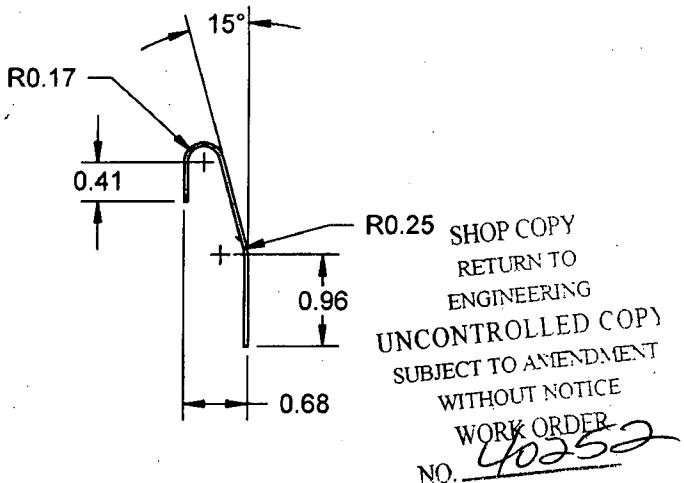
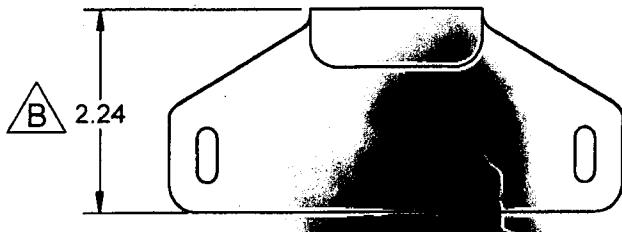
## X First Article      Prototype

Measured by:	<i>PB</i>	Audited by:	<i>C</i>	Prototype Approval:	N/A
Date:	9-7-17	Date:	<i>08/07/18</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE BRACKET	SCALE 1:2
REV A	DATE 03.08.05	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.01	DESCRIPTION 2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

**RELEASED***06.11.20 ✓***D3199-1 FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 0018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



